



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3640-1
Job Sheet 176060



Part No: D3640-1

Job Qty: 8 ea

Part Name: Belt Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		4/28/18	0.00	0.00	Start Up Machining-2		DAS 18/04/20
100	Bandsaw	8 pcs		4/28/18	0.00	0.18	Bandsaw1		52 18/04/20
110	CNC Vertical Machining	8 pcs		4/30/18	0.33	2.48	HAAS1-4		9-89 18/04/20
130	QC	8 pcs		4/30/18	0.00	0.00	QC8 Machining-2		
140	Packaging	8 pcs		4/30/18	0.00	0.00	Packaging3-1		
150	QC21-SA	8 Ea		4/30/18	0.00	0.00	QC21		

Part Op 100 - Cut blank 4.700 " long

Descriptions: 110 - 1- Mill as per Folio FA670 & Dwg D3640 Rev: _____ 2-Deburr and Blend rad intersection with deburring tool.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB0.750X1.250	Delrin Bar	3.2000 ft (.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINB0.750X1.250 1.000	3	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Belt Guide	4.500Inches ± 0.030	4.530 4.470	4.500	
2	Belt Guide	0.800Inches ± 0.030	0.830 0.770	.803	
3	Belt Guide	0.130Inches ± 0.030	0.160 0.100	.122	
4	Belt Guide	0.310Inches ± 0.030	0.340 0.280	.312	
5	Belt Guide	0.200Inches ± 0.010	0.210 0.190	.201	
6	Belt Guide	0.400Inches ± 0.030	0.430 0.370	.400	
7	Belt Guide	0.030Inches ± 0.030	0.060 0.000	.030	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																			
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 CANADA
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Container No: S063121
 Part: D3640-1
 Job No: 176060
 Serial No/Batch: S063121
 Revision:
 Inspector:

Date: 04/20/18

8	Belt Guide	45.000Degrees ± 0.500	45.500 44.500	45° Angle
9	Belt Guide	0.230Inches ± 0.030	0.260 0.200	.229
10	Belt Guide	0.400Inches ± 0.030	0.430 0.370	.397
11	Belt Guide	0.625Inches ± 0.010	0.635 0.615	.627
12	Belt Guide	0.130Inches ± 0.030	0.160 0.100	.130 Radius

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DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :						